

5/45



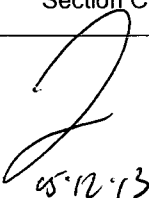

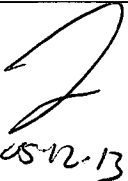
DART AEROSPACE LTD	Work Order:	24546
Description: Basket Rib	Part Number:	D3166-3
Dwg: D3166 Rev. A1	Qty:	10
24.05.21		Page 1 of 1


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	HT	05.10.13	10
2	LB	Cut 3/4" x 3/4" square tubing 120.00" long. Material: 304/316 SS tube 0.063" wall Batch M18907	DP	05/10/13	10
3	LB	Form D3166-3 Basket Hoop as per Dwg D3166 using Bending program 350 BASL. and Folio FT005	pmc	05-11-23	9
4	QC6	Inspect Basket Hoop dimensions with template D3166-3-T1 (DT8303)	PD	05-12-9	9
5	LB	Identify and Stock LB Cell	PD	05-12-12	9
6	AC	Cost / part	595	05/12/14	9
7	DC	Close W/O Inspect Level 21	OP	05/12/13	9

Rev	Date	Change	Revised By	Approved
A	02.08.23	New issue	KJ RF	PTO

RELEASED
02/08/27 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/12/09	3	Scrap one Hoop when bending		destroy it	 05-12-09	 05-12-13		 05-12-13

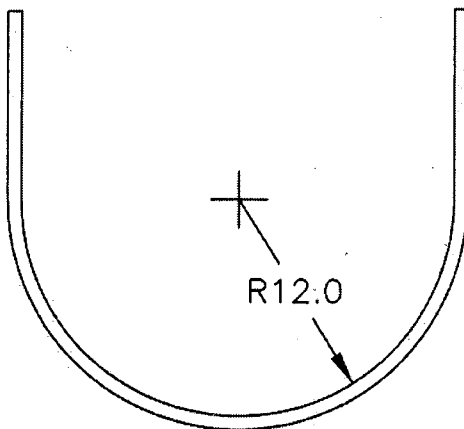
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/12/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

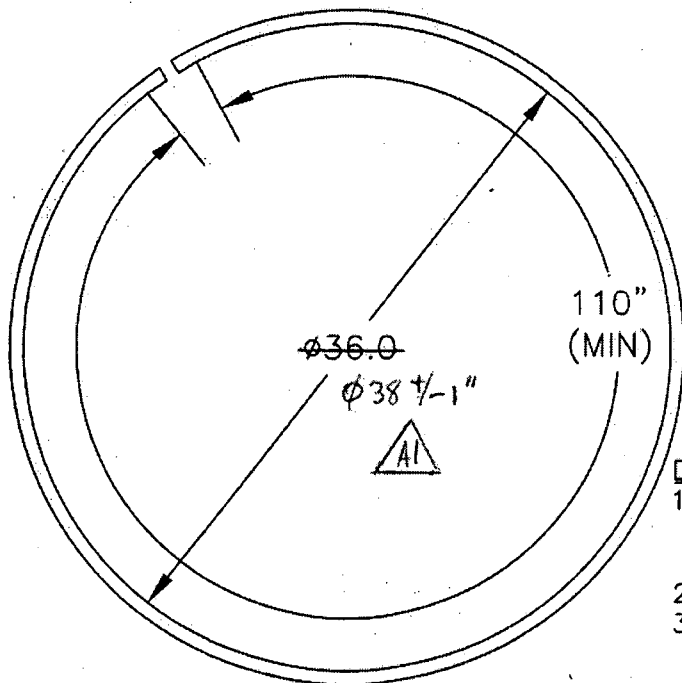
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 WAS 36.0	

RELEASED
02.08.06

10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

**SHOP COPY**
RETURN TO
ENGINEERING**UNCONTROLLED COPY**
SUBJECT TO AMENDMENT
WITHOUT NOTICE**WORK ORDER**NO. 24546**D3166-3 BASKET HOOP**

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 13, 2005
10:00 am

Work Order No : 0024546
Project Name : D3166-3
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D3166-3
Description : Basket Hoop
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 10-12-05
Est Finish Date : 11-08-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:23 pm

Work Order No : 0024546
Project Name : D3166-3
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D3166-3
Description : Basket Hoop
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 10-12-05
Est Finish Date : 11-08-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.25	100.00		
Production Cost :	0.00	3.88	100.00	0.00	3.88
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	3.88	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	3.88			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-3.88)

MIS 7/13
11-13

Date: Monday, 14/11/2005 8:17:06 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET RIB
Job Number :	24546		
Estimate Number :	10404		
P.O. Number :		Part Number :	D31663
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3166 REV A1
First Issue :	//	Project Number :	
Previous Run :		Drawing Revision :	A1
	Type :	Material :	
	LANDING GEAR	Due Date :	30/11/2005
Written By :		Qty:	10
Checked & Approved By :		Um:	Each
Comment :	Est. A 02.08.23 New issue KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

Cut 3/4" x 3/4" square tubing 120.00" long.

3.0	BENDING	BENDING MACHINE
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**Comment:** BENDING MACHINE

Form D3166-3 Basket Hoop as per Dwg D3166 using Bending program 350 BASL, and Folio FT005

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect Basket Hoop dimensions with template D3166-3-T1 (DT8303)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion

